

Date: Tuesday, 24/06/2008 1:02:21 PM  
User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT PLATE  
Job Number : 40027  
Estimate Number : 13385  
P.O. Number :  
This Issue : 24/06/2008 S.O. No. :  
Prsht Rev. : NC Part Number : PB6743001-71  
First Issue : / / Type : SMALL / MED FAB Drawing Number : B6743001 PAGE26  
Previous Run : Material :  
Written By : Due Date : 01/07/2008 Qty: 10 MF Um: Each  
Checked & Approved By : MF 08-06-24  
Comment : Est Rev:A 08-06-19 new issue DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.8594 sf(s)/Unit Total : 4.2971 sf(s)  
6061-T6 .090 Sheet  
batch: 19295 IB 8-6-24

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg B67-43001-159  
Dwg Rev: B1 IB 8-6-24  
Prog Rev: B1  
\*\*\*\*grain direction along 5.750" \*\*\*\*  
2-Deburr if necessary IB 8-6-24

14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
Bend as per Dwg B67-43001

4.1 Counter sink as per dwg

SB 08/06/25 (14)  
EB 08/06/25 (14)

08/06/25 42 Qc 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:02:21 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40027

Part Number: PB6743001159

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/66/25 (+14)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld as per dwg B67-43001

08.06.27

8.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)

Nutplate

M108601

08/07/17

9.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

RIVET

M105978

08/07/17

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

1- install nut plates as per dwg B67-43001

08/07/17 (+14)

11.0

QC5

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/7/17 (+14)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1114

08.07.18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/06/27	7.1	Small fab grind weld flush	SAD	08/04/07	4		
	7.2	QC 10			714		
	7.3	QC 5			714		
	7.4	Hand Finish chemical conversion coat	SAD	08/07/07	14		
	7.5	QC 3	S	08/07/17	(14)		
		* All permanent change		NA	08/06/27		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:02:21 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40027

Part Number: PB6743001159

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/05/28

Job Completion



u 08.08.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



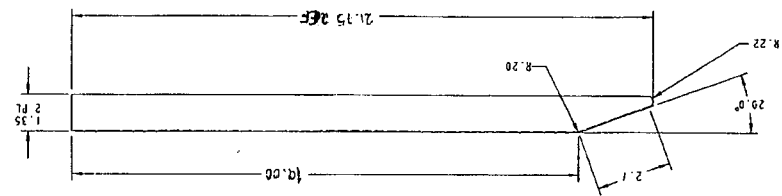
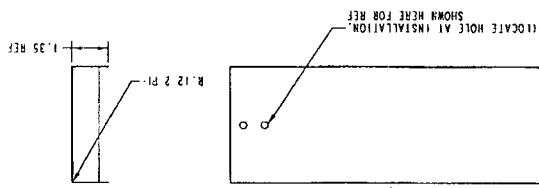
ORIGINAL

PREMIER AVIATION, INC.  
3000 AVIATION PARKWAY, CLEVELAND, OHIO 44130  
REV. 01/80  
B67-43001  
SCALE: 0.500

REFERENCE ONLY

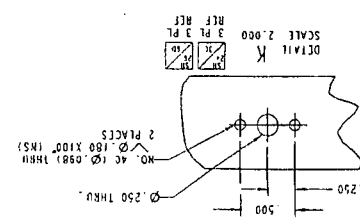
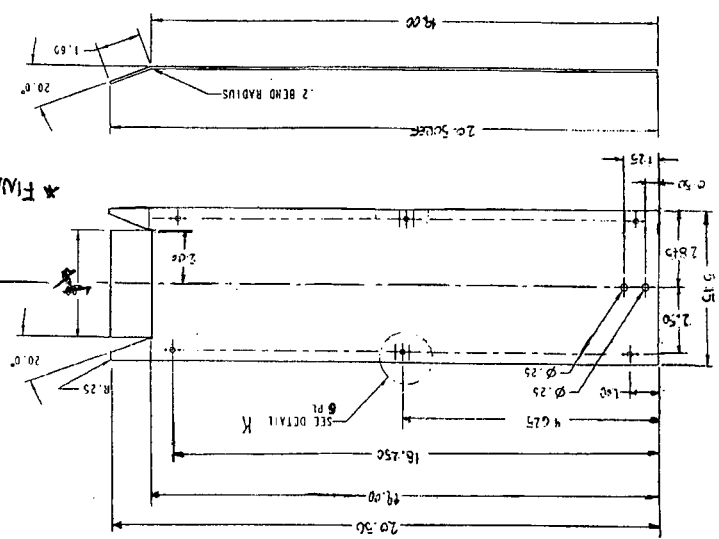
② -73 20 DEGREE COVER PLATE  
SCALE: 0.500  
MATERIAL: 0.032 THK. 6061-T6, 00-A-250/11

\* FINAL DIM OF BEWBW: 4.0



RELEASED  
406-1-20

② -159 SUPPORT PLATE  
SCALE: 0.500  
MATERIAL: 0.032 THK. 6061-T6, 00-A-250/11  
Part 13 SYMMETRICAL ABOUT CENTER LINE  
#40027





Date: Friday, 7/4/2008 8:45:48 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT PLATE
Job Number : 40244	
Estimate Number : 13385	
P.O. Number :	Part Number : PB674300171
This Issue : 7/4/2008 S.O. No. :	Drawing Number : B6743001 P.9/26
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 40027	Material :
Written By :	Due Date : 7/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>08 07.04</u>	
Comment : Est Rev:A 08-06-19 new issue DD verified by:ec	
Est Rev:B 08-06-27 procedure chg DD verified by:EC	<i>see first page</i>

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.8594 sf(s)/Unit Total : 8.5943 sf(s)  
 6061-T6 .090 Sheet  
 batch: \_\_\_\_\_

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg B67-43001-159  
 Dwg Rev: \_\_\_\_\_  
 Prog Rev: \_\_\_\_\_  
 \*\*\*\*grain direction along 5.750" \*\*\*\*  
 2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Bend as per Dwg B67-43001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 7/4/2008 8:45:48 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40244

Part Number: PB674300171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1- weld as per dwg B67-43001

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-grind weld flush

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)  
Nutplate

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)  
RIVET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:48 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40244

Part Number: PB674300171

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-install nut plates as per dwg B67-43001

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

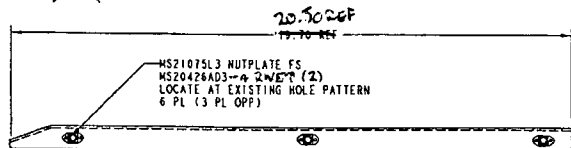
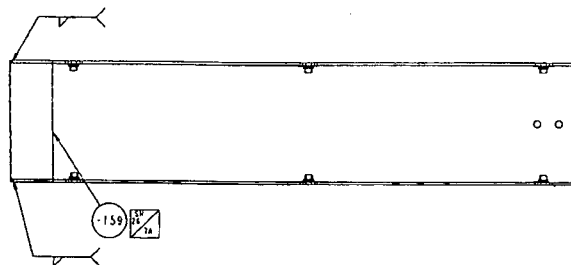
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

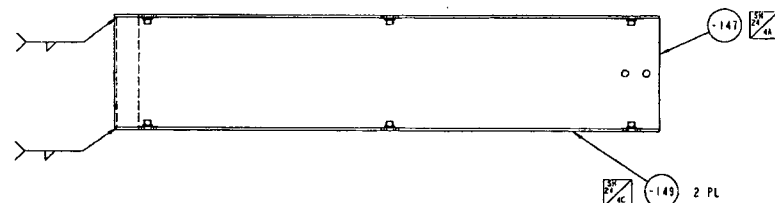
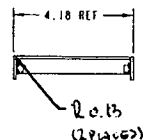
**NOTE:** Date & initial all entries

RELEASED



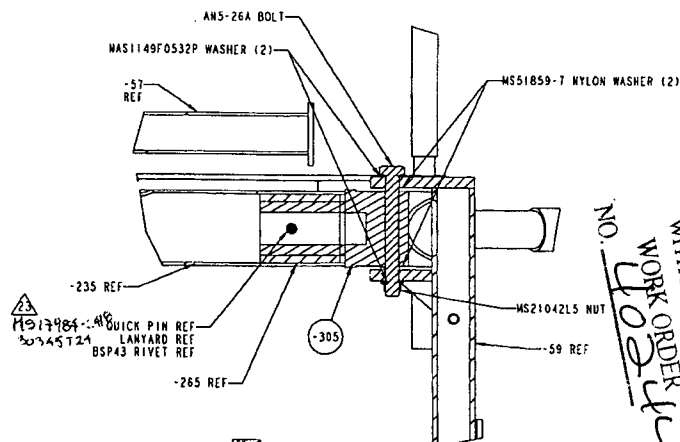
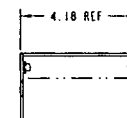
② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



DETAIL A  
SCALE 0.750  
(-03 ASSY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 40044  
WORK ORDER

PREMIER AVIATION, INC.	
3000 Aviation Parkway, Grand Prairie, Texas 75052	
SIZE CODE (BLANK) NO.	REV NO.
D10SUV8	867-43001
SCALE:	SHEET 8 OF 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

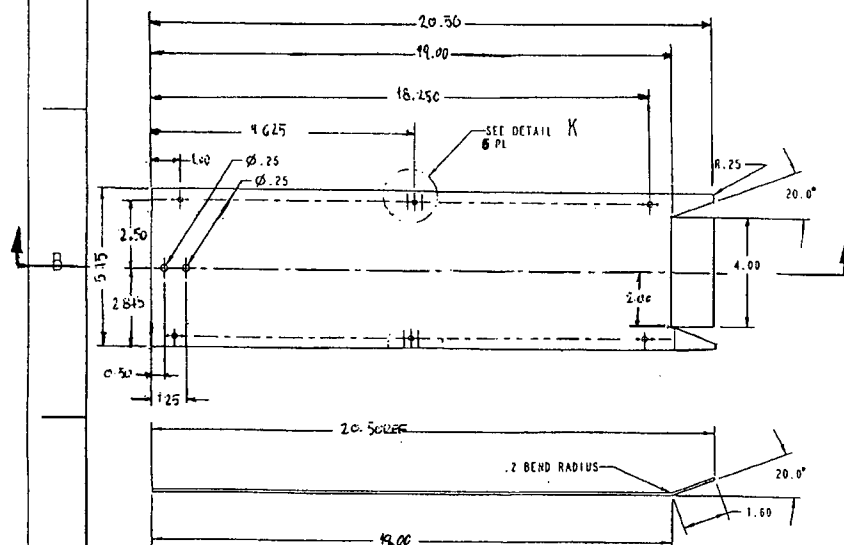
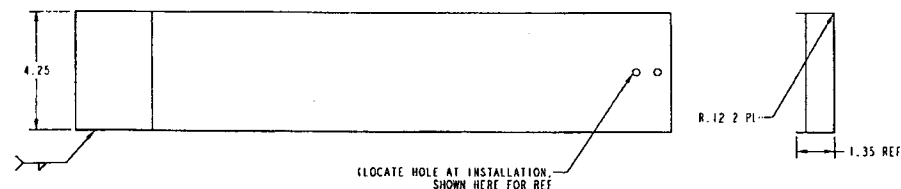
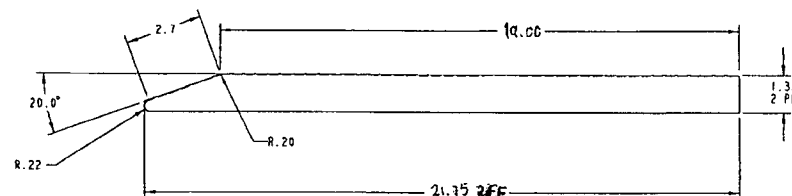
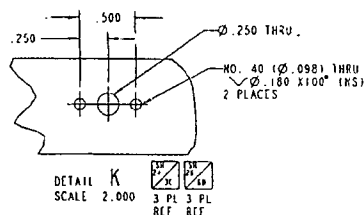
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED  
4-26-61-20



② -159 SUPPORT PLATE  
MATL: .090 THK, 6061-T6, 00-A-250/11  
SCALE 0.500

PART IS SYMMETRICAL ABOUT CENTER LINE

② -73 20 DEGREE COVER PLATE  
MATL: .032 THK, 6061-T6, 00-A-250/11  
SCALE 0.500

NO. 40214  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
SHOP COPY  
RETURN TO  
ENGINEERING

PREMIER AVIATION, INC.  
3901 Aviation Parkway, Grand Prairie, Texas 75052  
D105UV8 B67-43001  
SCALE: 26 W. 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries